

Work Order ID 86960

July-09-12 3:01:06 PM

86960

Page 1

Item ID: D2163 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Console Trim Angle
 Start Date: 7/09/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2163	Rev B								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2163 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary
 5052.050

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

0.00 SymB 12-7-05
 DAS 12-7-05
 17/09/12

10

B12-7-05

B12-7-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
	Memo START TIME: 12:50 FINISH TIME: 1:20	0.00				10X			M-L 12/08/23
170 *170* QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00				100		4	M 12/08/23
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: 006	0.00							SF 12/18/23
	Memo	0.00							

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Item ID: D2163

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Console Trim Angle

Start Date: 7/09/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 12/08/24

CMF
12-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 86960
Parent Item: D2163
Parent Item Name: Console Trim Angle

Start Date: 7/09/12
Start Qty: 6.00
Required Date: 8/10/12
Required Qty: 6.00

Comments: IPP: F02.05.11Clarify IPP NG
 IPP Rev:G 07-11-08 Now On Waterjet JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.050 5052-H32 .050 Sheet		Purchased	No			110	sf	226.0000	0.0694	0.4383156	1.		

B12-9-25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	226	
115389	64	
116268	64	
118654	64	
14050	2	
4894	32	

116268

(10)

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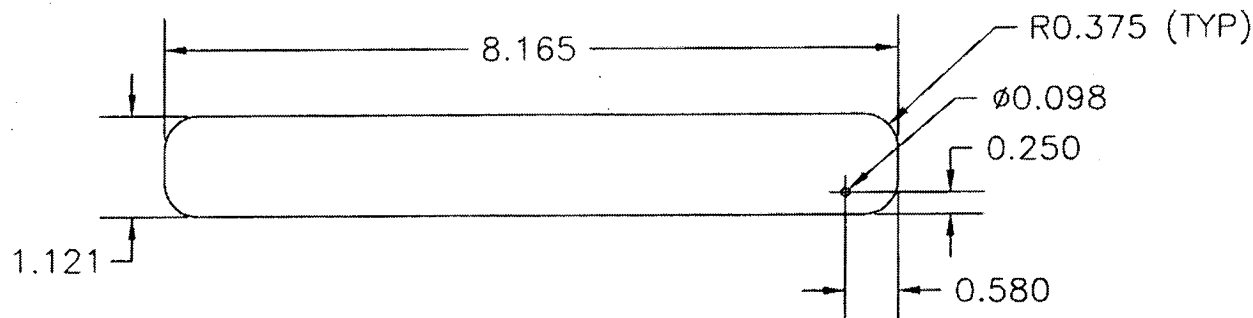
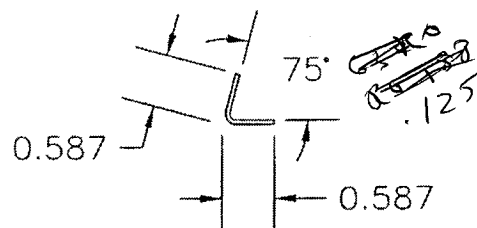
DART



RELEASED
97.11.04 KE
TSR A421

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86960 M5

12/07/10



MATERIAL: 5052-H32 (QQ-A-250/8) 0.050 THICK
FINISH: POWER COAT MATTE BLACK PER DART QSI 005 4.3

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED KE	APPROVED Bw	REV. B
DATE 97.10.30	DRAWING NO. D2163	SHEET 1 OF 1
	TITLE TRIM ANGLE	SCALE 1:2
A	95.05.19	RE-DRAWN
B	97.10.30	REMOVE BEND DATA

W/O:		WORK ORDER CHANGES					
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